

BLUE

4/10/07

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CAP
Job Number	: 32375		
Estimate Number	: 10312		
P.O. Number	: N/A	Part Number	: D2646 <i>UP</i>
This Issue	: 5/16/2007	Drawing Number	: D2646 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i>	Drawing Revision	: C
Previous Run	: 31335	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 6/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	16 Um: Each
Comment	Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev: H Changed Inserts 07-02-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *3794*

0207105116

(16)

1-Spin as per Dwg D2646

2-Material release note required

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to *250* and *250* as per Dwg D2646.

3-Deburr

1297 CE 07-06-11

[Signature] 07/06/12 *(16)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
2006.13	5.0	Add QCS for work inspection. QCS	J	2006.13	16	2006.13	2006.13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

WJ

07-06-13

16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

NIA

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

INSERT

Batch: _____

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock updated

7/7/5 (8)

57473

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-05	7	Split to send to outside supplier (+2) for parity	U	07-06-05	2	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 5 Date: 01/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007/07/06 (12)

Job Completion



W 07.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ FAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

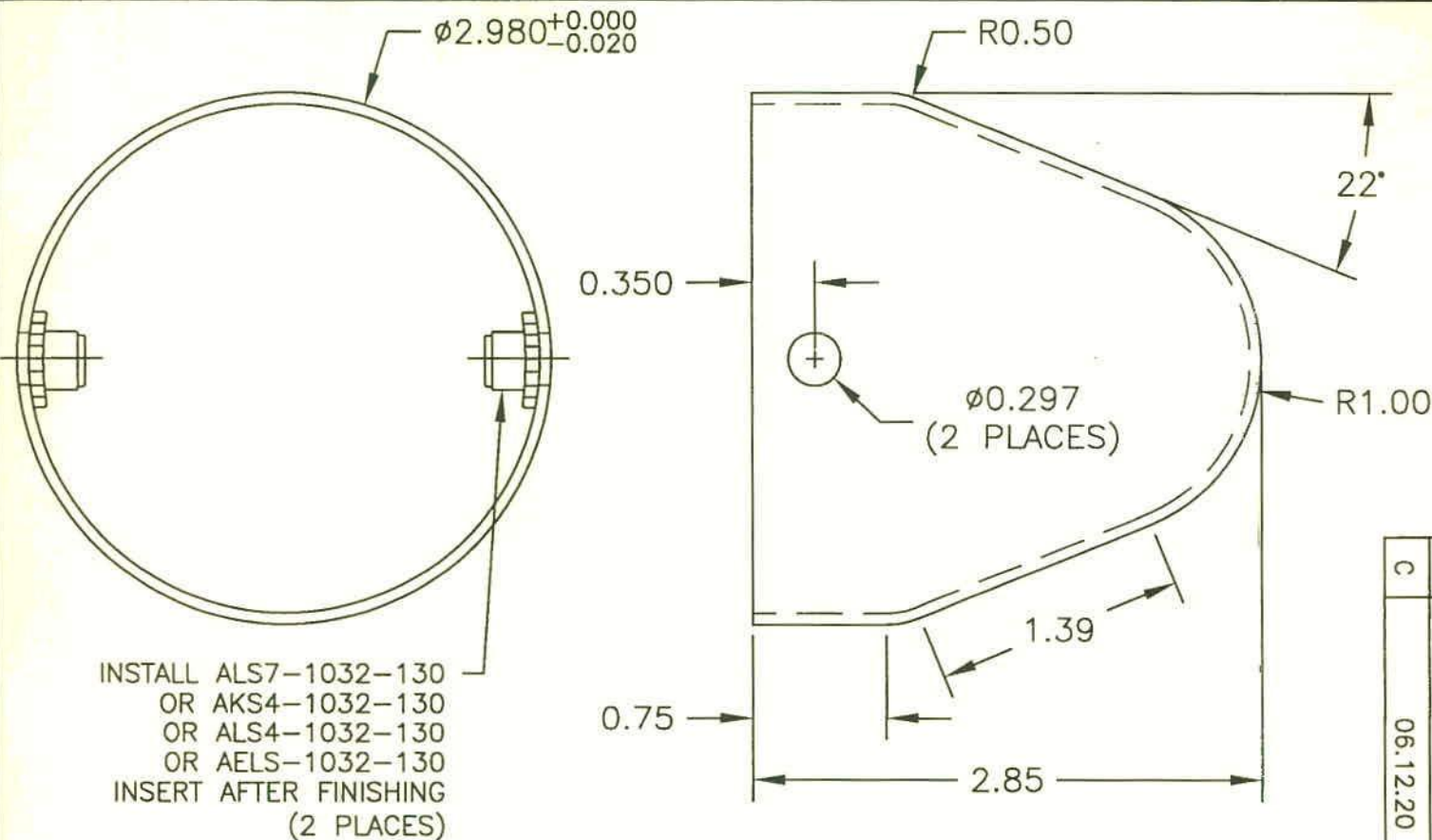
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1	
A	97.03.25	NEW ISSUE				
B	05.04.01	CHANGE TO CLOSED INSERTS				
C	06.12.20	CHANGE TO OPEN ENDED INSERTS				

**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

07.02.20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32375

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1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILK ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9.760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.014	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten:
HAW
Henry @ SHR
C/O
Sore @
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By: JEFF FREANY, LAB SUPERVISOR

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Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 4/07
Customer: Dart Aerospace
Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
B32375	16 ✓	1A61100	N/A	✓	
B32427	50	1A61100	N/A	✓	

Notes:

Material Certification Attached: Yes.

